

Date: Friday, 12/7/2007 10:20:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT WEB
Job Number	: 36187		
Estimate Number	: 10792		
P.O. Number	: <i>N/A</i>	Part Number	: D3289041
This Issue	: 12/7/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3289 REV <i>9 D</i>
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 32782	Drawing Revision	: <i>8 D</i>
	Type : LANDING GEAR	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 12/24/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	10 Um: Each
Comment	Est Rev:A 04-09-28 New Issue KJ/JLM Est Rev:B 07-09-09 As per Rev C JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-5-108

Web

*B29985**DP**7-12-10*

2.0	D32833	Doubler
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-3

Doubler

26793

3.0	MS20470AD47	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 85.0000 Each(s)/Unit Total : 850.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

85 MS20470AD4-7

Rivet

*104936**875*

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5-108 to as per Dwg D3289

2-Transfer drill web from D3283-3 doublers

3-Drill web using DT8748 as per Dwg D3289

Holes moved

SL 7-12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/11/2007 10:20:59 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 36187

Part Number: D3289041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Using uni-bit, open holes as per Dwg D3289

5-Deburr holes and ends

SL 7-12-11

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

JO 7-12-12

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 7-12-12

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Rivet doublers as per Dwg D3289

A/R LPS-3 Batch: 103674

(10)

SL 7-12-12

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 12/13 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G

(10)

H

7-12-13

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)
12/12/13

Job Completion



W 07.12.13

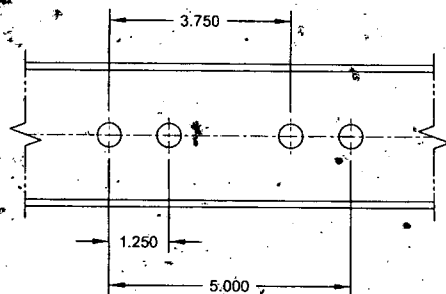
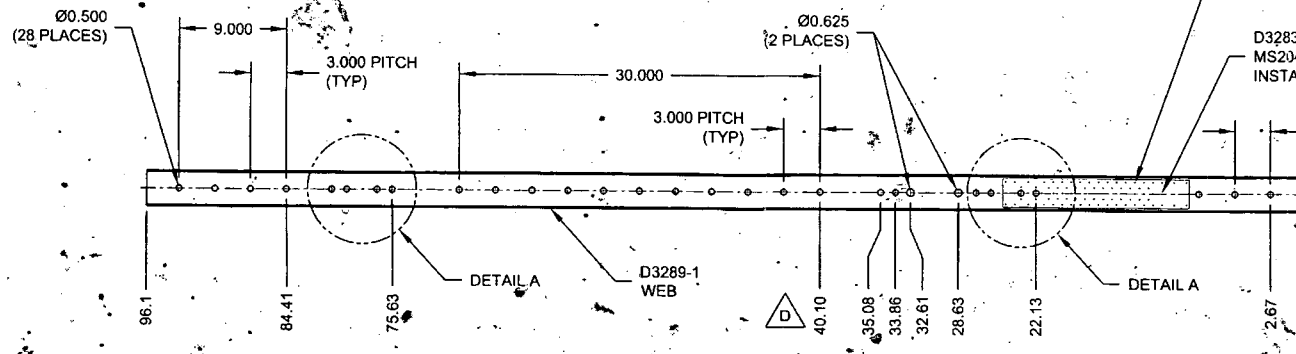
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A
(RIVET HOLES NOT SHOWN)
SCALE 1:5

D3289-041 FLOAT WEB

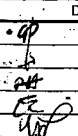
Qty	Part Number	Description
X	D3289-041	FLOAT WEB
1	D2600-5-108	EXTRUSION
2	D3283-3	DOUBLER
85	MS20470AD4-7	RIVET

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5-108 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-3 DOUBLERS AND D3289-1 WEB. INSTALL RIVETS COATED IN LPS LABORATORIES LPS-3
- 7) WEIGHT: 5.00 lbs

NO
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
07.11.13

D	MID-FLOAT HOLES ON D3288 WERE MOVED 2.00" FWD & ROTATED INBOARD & OUTBOARD BY 17° DUE TO GHW INTERFERENCE. THEREFORE, 40.10 WAS 38.10.	MB	07.09.14
C	CORRECTED TYPO (-3 WAS -1)	MB	07.06.04
B	ADD HOLES FOR OEM COMPATIBILITY	CP	05.03.16
A	NEW ISSUE	CP	04.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.14		
DRAWING NO.		REV. D	
D3289		SHEET 1 OF 1	
TITLE		SCALE	
FLOAT WEB, 206A/B		1:1	
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DART AEROSPACE LTD		Work Order: 36187
Description: Float Web		Part Number: D3289041
Inspection Dwg: D3289	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.67	QSI 18	2.67				
22.13		22.13				
28.63		28.63				
32.61		32.61				
33.86		33.86				
35.08		35.08				
40.10		40.10				
3.000 (typ)		3.000				
30.000		30.000				
84.41		84.41				
96.1		96.6				
9.000		9.000				
3.000 (typ)		3.000				
Detail A						
1.250		1.250				
3.250		3.250				
5.000		5.000				

Measured by:	Audited by:	Prototype Approval:
Date: 7-12-10	Date: 7-12-10	Date: 07.12.10

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

